

D4542-3

B106337

Work Order ID 106337

D4542-3

106337

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August-29-13 8:19:42 AM

B106337

Item ID: D4542-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner

Start Date: 8/29/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4542

D

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1- Cut as per dwg

Prog rev: 2Dwg rev: D

2- Deburr

20 0 JmB-09-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

20 0 JmB-09-10

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August-29-13 8:19:42 AM

Item ID: D4542-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner

Start Date: 8/29/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20			
124 *124* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20			
126 *126* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				20			

22

23

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Work Order ID 106337

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Item ID: D4542-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, Inner
 Start Date: 8/29/13 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST532</u>	0.00							
130						20X	28	13-09-10	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/9/11

3

Picklist Print

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Work Order ID: 106337
 Parent Item: D4542-3
 Parent Item Name: Retainer, Inner

Start Date: 8/29/13 Required Date: 9/13/13
 Start Qty: 20.00 Required Qty: 20.00

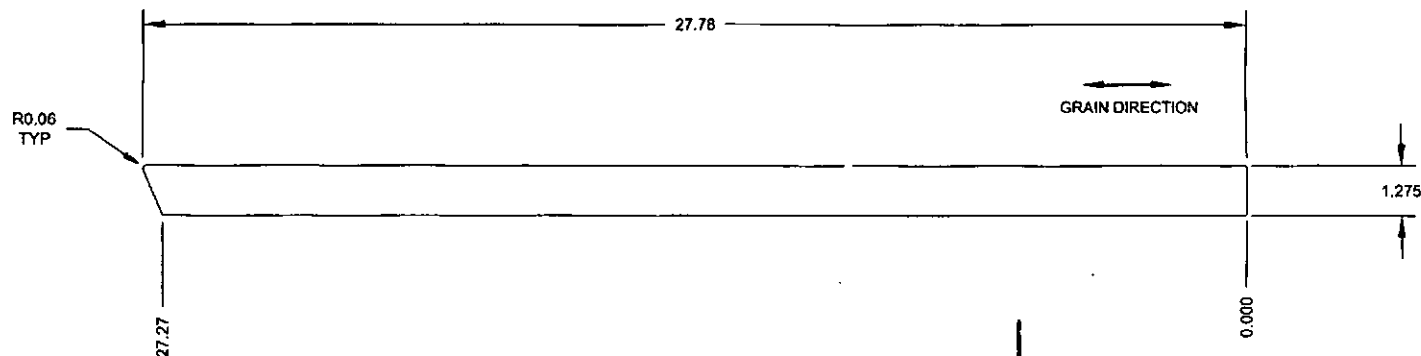
Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
 reva DD verf:EC IPP REV:C 12.05.08 as per dwg revB DD verf:EC IPP
 REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	1,096.1660	0.252	53052632			
										5.5			Jm1309-10
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		1096.166							
				123135		8.5							
				123137		10							
				123293		10							
				123483		256.6							
				m125822		67.3							
				m126115		74.866							
				m126147		305.15							
				m126309		363.75							
										126309			

DART AEROSPACE LTD		Work Order: 106387
Description: Retainer, Inner		Part Number: D4542-3
Inspection Dwg: D4542	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>Jm</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: <i>13-09-10</i>	Date: <i>13 9 10</i>	Date:



D4542-3 RETAINER, INNER
(SIDE)



106387

RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lbs
- 8) PROFILE PER DRAWING FILE "D4542-3-REV.DXF"

DESIGN	<i>P</i>	DART AEROSPACE LTD	
DRAWN	<i>P</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
DATE	13.02.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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